



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D117-762-041
Job Sheet 171217



Part No: D117-762-041

Job Qty: 1 ea

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/28/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF
by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV.C (ecn16-514)
DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S044344



Part: D117-762-041

Job No: 171217

Serial No/Batch: S044344

Revision: D3582 PRELIM.

Inspector:

Date: 02/21/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/27/18	0.00	0.00	Start Up Skid tubes-1		
130	Skid tubes	1 pcs		2/27/18	0.00	3.47	Skid tubes-1		BB
140	Skid tubes	1 pcs		2/27/18	0.00	3.47	Skid tubes-1		BB
150	QC	1 pcs		2/27/18	0.00	0.00	QC10		BB
160	QC	1 pcs		2/27/18	0.00	0.00	QC5		BB
170	Hand Finish	1 pcs		2/27/18	0.00	0.97	HandFinish1		BB
180	QC	1 pcs		2/27/18	0.00	0.00	QC7-1		BB
190	Skid tubes	1 pcs		2/27/18	0.00	3.47	Skid tubes-1		BB
200	QC	1 pcs		2/27/18	0.00	0.00	QC10		BB
210	QC	1 pcs		2/27/18	0.00	0.00	QC5		BB
215	Hand Finish	1 pcs		2/27/18	0.00	0.97	HandFinish2		BB
220	Powdercoat	1 pcs		2/27/18	0.00	0.26	Powdercoat1		BB
230	QC	1 pcs		2/27/18	0.00	0.00	QC3		BB
250	Hand Finish	1 pcs		2/28/18	0.00	0.97	HandFinish4		BB
260	QC	1 pcs		2/28/18	0.00	0.00	QC5		BB
265	DC	1 pcs		2/28/18	0.00	0.00	DC		BB
270	Packaging	1 pcs		2/28/18	0.00	0.00	Packaging3-1		BB
280	QC21-FG	1 Ea		2/28/18	0.00	0.00	QC21		BB

Part Op
Descriptions:

1 - 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN AFT CAP HOLE TO .187" 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16 cleco in Ground wire hole 6-Drill all X-Bolt holes using 3/16" drill. 7-Drill pilot holes for wearplates using DT8900 8-Open wearplate holes to 9/64" (0.297") as per Dwg D3582. 9-Drill holes for D5520-1 doubler using DT10309 A & B, locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleco as you go. Remove .1875 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 10-Deburr doubler and doubler holes in skid tube. 11-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine on D5520-1 doublers. 12-Open ground wear holes to 0.391" as per section B-B 13-Open Aft Cap holes using .209" drill. 14-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 15-Do not open holes of section G-G to finishes size.

140 - 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD Batch: m138673 2-Grind flush

190 - ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E and G-G.***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sika Flex Batch: BB 787 Exp Date: APR 21 2018 6- Swage x-bolt spacer as per dwg and Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD Batch: m138673 8-Grind welds flush

215 - Touch-up alodine as per QSI

220 - START TIME 8:10 OVEN TEMPERATURE: 320°F FINISH TIME: 8:45

250 - 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex Batch: M 138831 Exp Date: 8/1/18 3-Install Wearplates as per Dwg D3582 , Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

265 - Photocopy bluefile & type labels per PPP D117-762-041 CHG003

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 Ea (1 ea)	90-Start up Operation	5042815
D5520-1	Doubler	2 Ea (2 ea)	130-Skidtubes	5004478 / 5044313
D2964	Cap	1 Ea (1 ea)	140-Skidtubes	F163672
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes	5013777
D2971	Cross Bolt Spacer	1 Ea (1 ea)	190-Skidtubes	8155918
D3584-1	Web	1 Ea (1 ea)	190-Skidtubes	5008578
D3662-1	Crossbolt Spacer	3 Ea (3 ea)	190-Skidtubes	F163443
D3662-3	Crossbolt Spacer	1 Ea (1 ea)	190-Skidtubes	F816006
D5304-1	Crossbolt Spacer	2 Ea (2 ea)	190-Skidtubes	5014375
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-HandFinish	5007279
ALS4-428-165	Insert	2 Ea (2 ea)	250-HandFinish	F11137054-0
AN3C4A	Bolt	28 Ea (28 ea)	250-HandFinish	5019394
AN4-4A	Bolt	2 Ea (2 ea)	250-HandFinish	5044215
D2965	Cap	1 Ea (1 ea)	250-HandFinish	5045471
D3508-11	Wearplate Aft Center	1 Ea (1 ea)	250-HandFinish	5036727
D3508-13	Wearplate Aft 5045060	1 Ea (1 ea)	250-HandFinish	5036730
D3508-3	Wearplate Fwd Center	1 Ea (1 ea)	250-HandFinish	5021061
D3508-9	Wearplate Fwd	1 Ea (1 ea)	250-HandFinish	5046166
D3558-11	Gasket Aft Center	1 Ea (1 ea)	250-HandFinish	5046147
D3558-13	Gasket Aft	1 Ea (1 ea)	250-HandFinish	5046190
D3558-3	Gasket Center Fwd	1 Ea (1 ea)	250-HandFinish	5023296
D3558-9	Gasket Fwd	1 Ea (1 ea)	250-HandFinish	
NAS1149C0332R	Washer	28 Ea (28 ea)	250-HandFinish	5041296
NAS1149D0332J	Washer	2 Ea (2 ea)	250-HandFinish	5020606
NAS1149D0416J	Washer	2 Ea (2 ea)	250-HandFinish	5041079
FH131511 001587				5045076
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3582-1-BENT	1	0	0
130-Skidtubes	D5520-1	2	16	0
140-Skidtubes	D2964	1	5	0
190-Skidtubes	CR3212-5-05	68	507	0
	D2971	1	13	0
	D3584-1	1	7	0
	D3662-1	3	17	0
	D3662-3	1	44	0
	D5304-1	2	35	0
250-HandFinish	ALS4-1032-130	36	8,839	0
	ALS4-428-165	2	25	0
	AN3C4A	28	1,994	0
	AN4-4A	2	32	0
	D2965	1	0	0
	D3508-11	1	11	0
	D3508-13	1	3	0
	D3508-3	1	10	0
	D3508-9	1	9	0
	D3558-11	1	8	0
	D3558-13	1	8	0
	D3558-3	1	3	0
	D3558-9	1	9	0
	NAS1149C0332R	28	3,091	0
	NAS1149D0332J	2	4,270	0
	NAS1149D0416J	2	3,346	0
Part Specifications				
Specifications could not be found.				

Plex 1/31/18 10:13 AM Dart.Gagnon.Michelle

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

ITEM	Qty -041	Part Number	Description
	X	D3582-041	SKIDTUBE ASSEMBLY
1	1	D2962-150	EXTRUSION
2	1	D2964	CAP
3	1	D2965	CAP
4	1	D2971	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-9	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3584-1	WEB
14	3	D3682-1	CROSS BOLT SPACER
15	1	D3682-3	CROSS BOLT SPACER
16	2	D5304-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1149C0332R	WASHER (AN960C10L)
22	2	NAS1149D0332J	WASHER (AN960JD10L)
23	2	NAS1149D0416J	WASHER (AN960JD416L)
24	38	AELS-1032-130	INSERT
25	2	AL87-428-165	INSERT
26	68	CR3212-5-05	CSK RIVET, CHERRY MAX

NOTES:

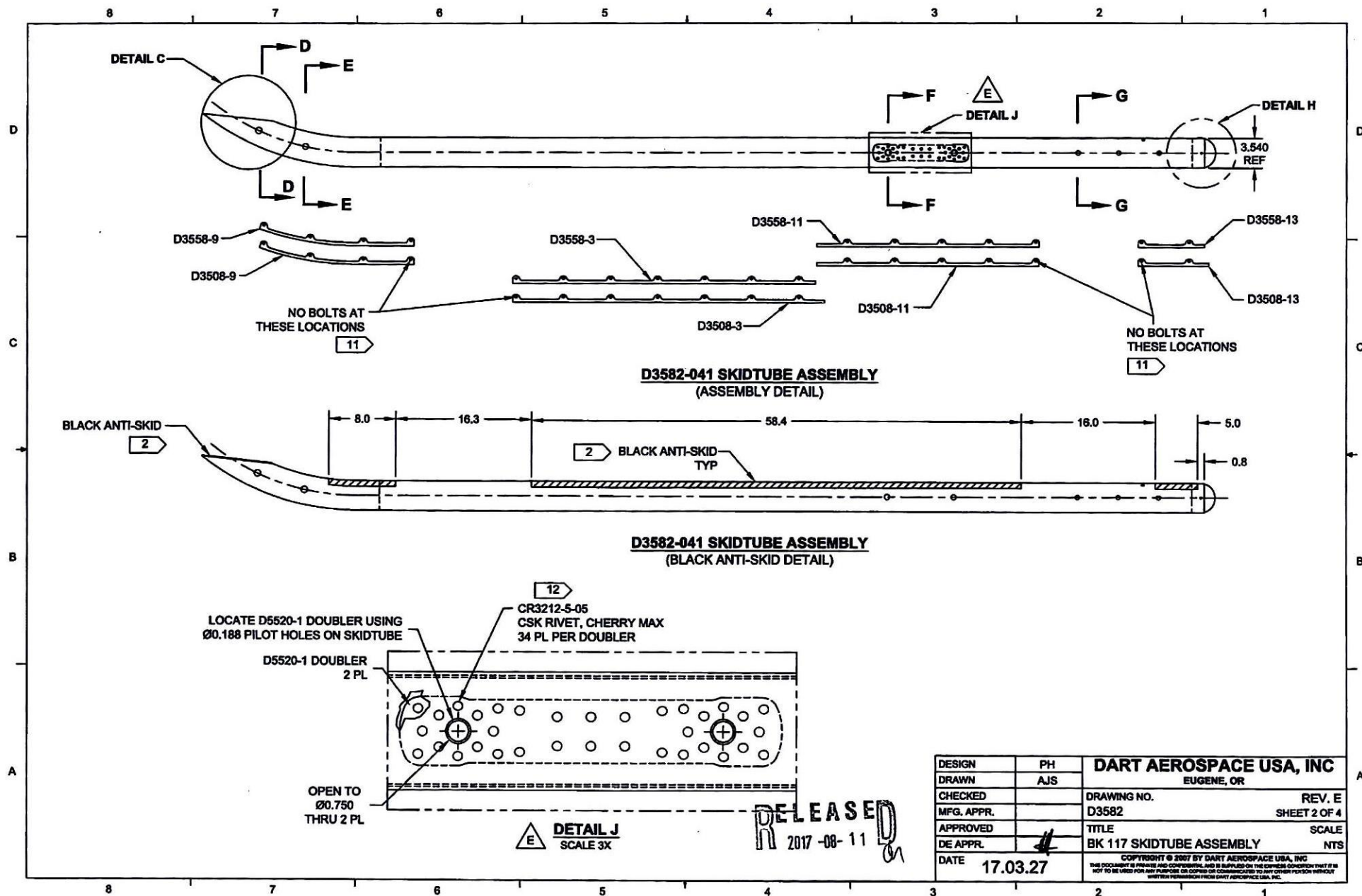
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 18.2 lbs
- 8) WELDING: PER DART QSI 004.
- 9) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 10) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS IN INDICATED LOCATIONS
- 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309. COUNTERSINK Ø0.288 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

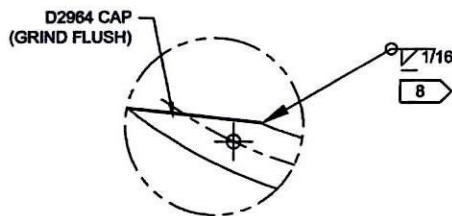
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 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 171217 *uml*

JAN 31 2018

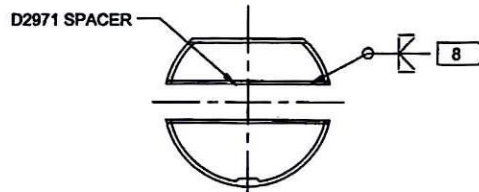
RELEASED
 2017-08-11
 EEN 17-547 *em*

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 26 AND NOTE 12-13. Ø0.167 HOLE WAS Ø0.75. ADD SHT 3, ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D5304-1 WAS D2973; REVISE BOM & SECTION F-F & SECTION NOTES (ZN B7-3, A8-3); REF NCR16-6160	RF	17.01.09
C	D3482 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	29.88 WAS 29.87 (ZN C2-1), INCORPORATED DEO D3582-A-1 (ZN D5-1), FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	EUGENE, OR	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3582	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BK 117 SKIDTUBE ASSEMBLY	NTS
DATE	17.03.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR MANUFACTURING TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



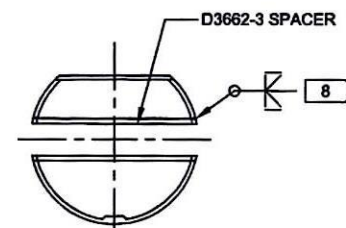


DETAIL C
SCALE 4X



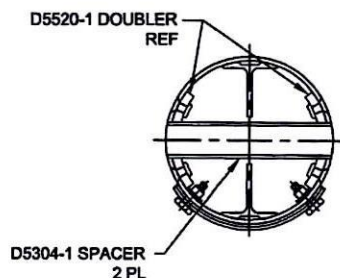
SECTION D-D
SCALE 4X

- SECTION D-D NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D2971 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER



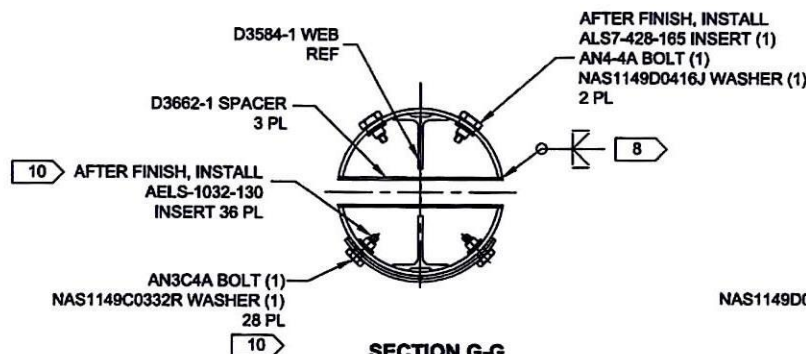
SECTION E-E
SCALE 4X

- SECTION E-E NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3662-3 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER



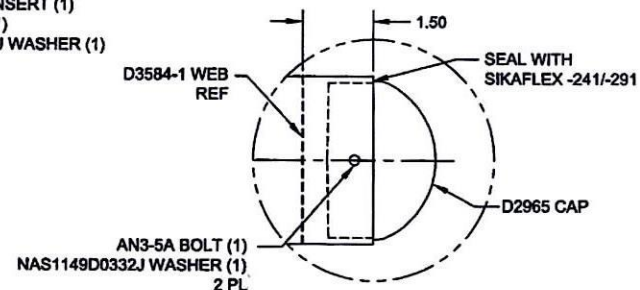
SECTION F-F
SCALE 4X
2 PL

- SECTION F-F NOTES**
AFTER BENDING AND DRILLING ASSY
PERFORM THE FOLLOWING:
1. INSERT D5304-1 SPACER
 2. SWAGE TO Ø0.585 +0.005/-0.000 X 1.0
DEEP PER QSI 002
 3. OPEN THRU HOLE TO Ø0.625
 4. GRIND FLUSH



SECTION G-G
SCALE 4X

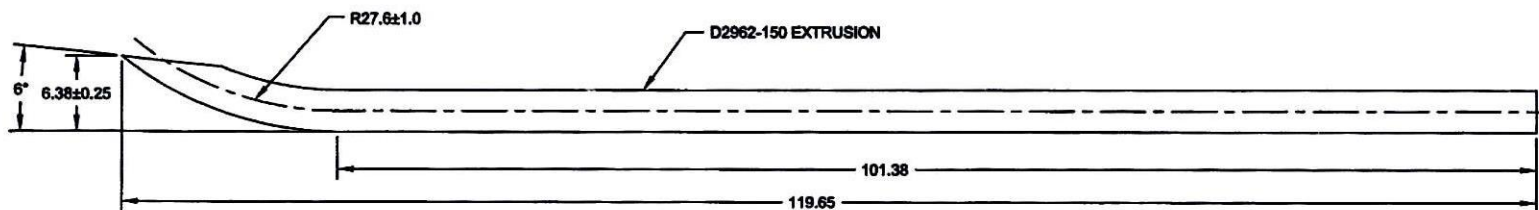
- SECTION G-G NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3662-1 SPACER (3 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER



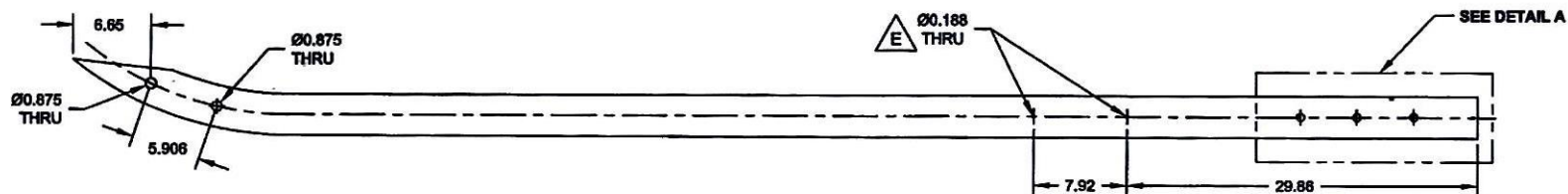
DETAIL H
SCALE 4X

DESIGN	PH	DART AEROSPACE USA, INC	
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MFG. APPR.		D3582	SHEET 3 OF 4
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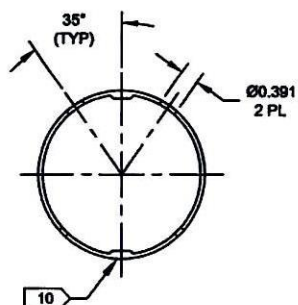
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2017-08-11



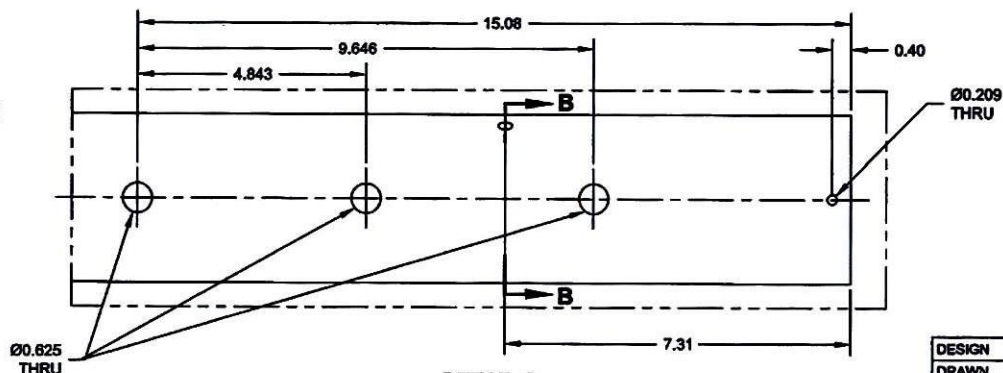
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 5X



DETAIL A
SCALE 5X

RELEASED
2017-08-11

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